

DREV 54868

Work Order ID 53897



November 23, 2009 11:26:39 AM

Item ID: D3290-3	Accept		Setup	Start	
Revision ID: C				Stop	
Item Name: Window					
Start Date: 23/11/2009	Start Qty: 8.00		Cust Item ID:		
Required Date: 27/11/2009	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: <u> <i>R</i> </u>	Date: <u>09-11-23</u>	Tooling:	Date:	Run	Start	
	QC: <u> </u>	Date: <u> </u>	SPC (Y/N): <u> </u>	Date: <u> </u>		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	Rev C								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3290 <input type="checkbox"/> Dwg Rev: <u> <i>C</i> </u> <input type="checkbox"/> Prog Rev: <u> <i>C</i> </u> <input type="checkbox"/> 2-Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

UB 9-11-27

(9)

UB 9-11-27

(8) *6*

2) 8 or 130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53897

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Item ID: D3290-3

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Setup Start



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Required Date: 27/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Without removing protective skin ☐ remove sharp edge by degurring.BB09/12/01
(X9)

140

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 ☐ Dwg.
Rev. C ☐ Folio Rev B ☐ 2-Engrave part# &
batch# ☐ (D3290-3)BB09/12/02
(X9)

150

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BB09/12/02
(X9)

W/O:		WORK ORDER CHANGES					
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Required Date: 27/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							OK 09/12/02 x9
170 	HAND FINISHING THERMOFORMING	0.00							
Thermoform Thermoforming Machine	Memo Water sand and buff to remove scratches if required	0.00							B 09/12/03 x9
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							278 09/12/07 (x9) /

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location: <i>st</i>	0.00				<i>9/12/30</i>		<i>QA</i>	<i>SP</i>
Packaging	Memo	0.00							
Packaging			<i>D3290-041</i>	<i>3AD</i>					
			<i>B54717 x8</i>	<i>09-12-30</i>					
200 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-01-05

BT 10-1-04

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 23, 2009 11:26:45 AM

Work Order ID: 53897



Parent Item: D3290-3RevC



Parent Item Name: Window

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MACRLICS.125

Purchased

No

100

sf

261.6270

25.2632

32.



189-11-27

1/8" Polycast II Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

261.627

110115

4

110633

17.2295

111711

67.7447

112888

0.7828

113204

171.87

113204

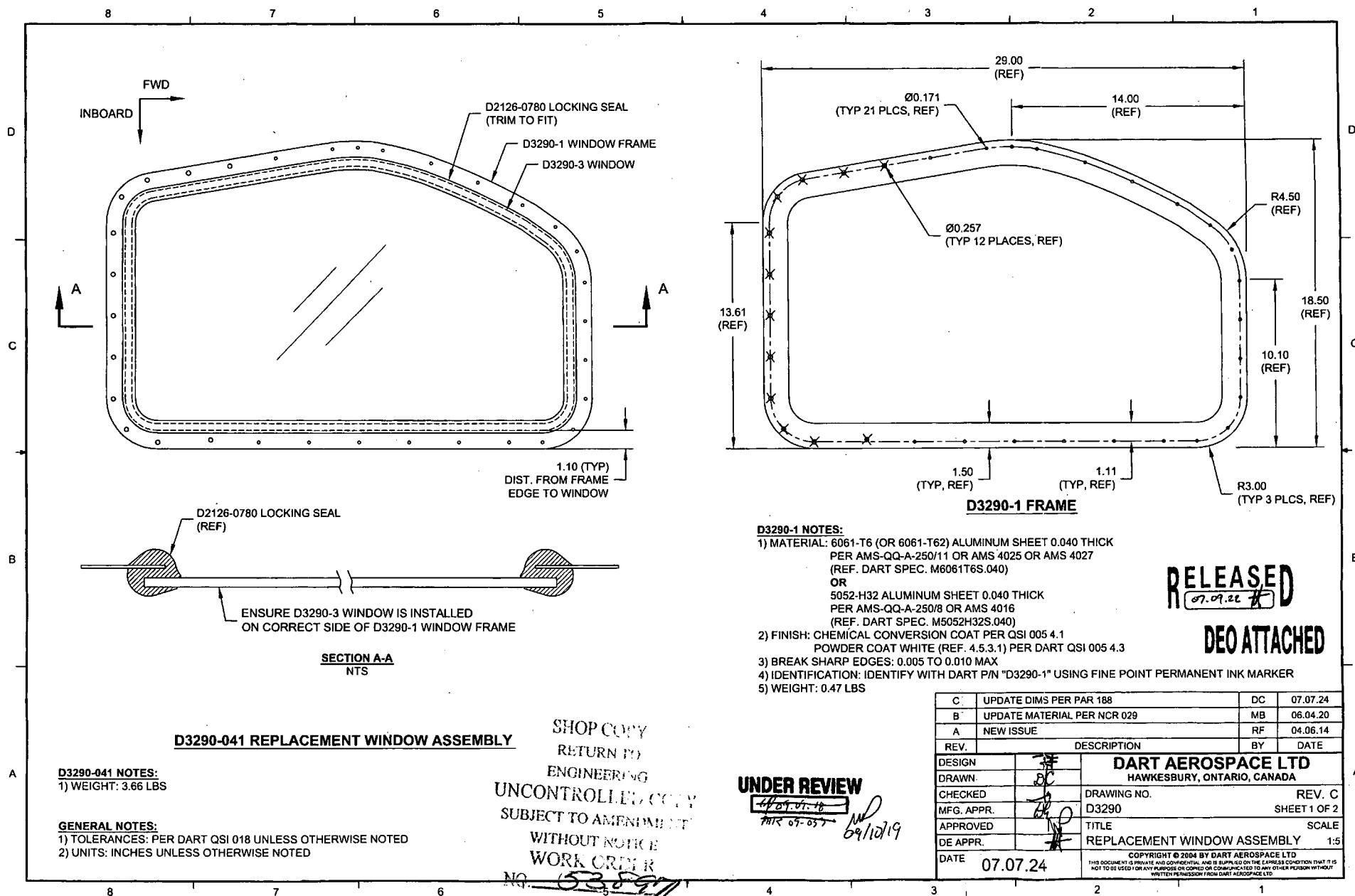
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

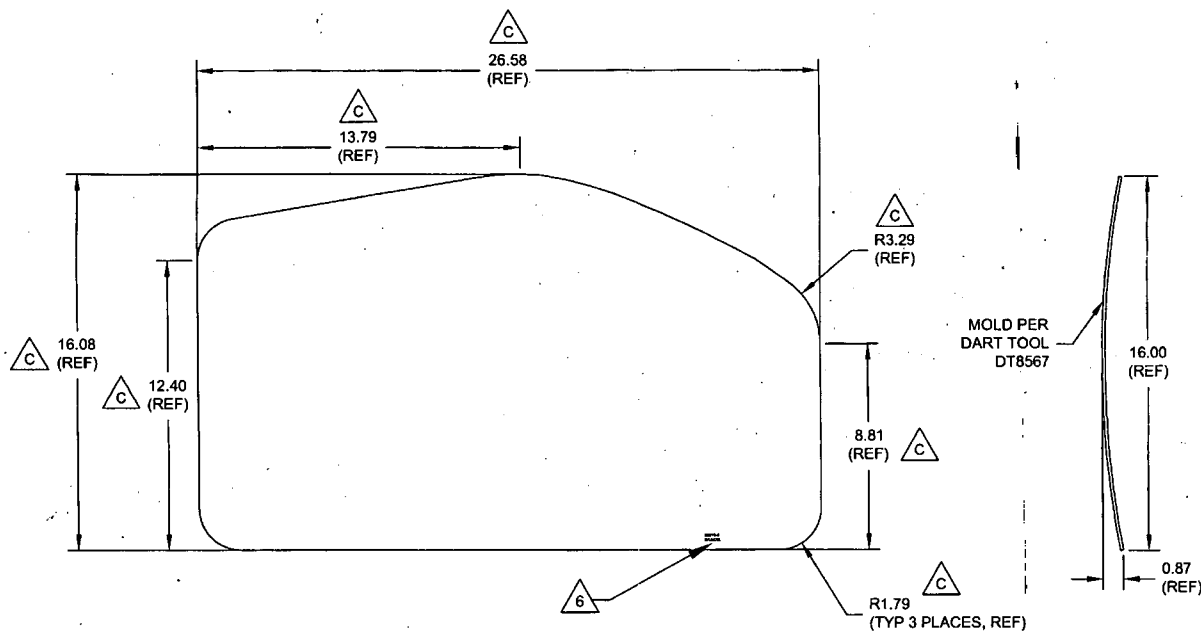
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NOTE: Date & initial all entries





D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

**DEO ATTACHED
RELEASED**
07.09.22 #

W/053897

DESIGN	W/053897	DART AEROSPACE LTD	
DRAWN	W/053897	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W/053897	DRAWING NO. D3290	REV. C
MFG. APPR.	W/053897	SHEET 2 OF 2	
APPROVED	W/053897	TITLE	SCALE
DE APPR.	W/053897	REPLACEMENT WINDOW ASSEMBLY	
DATE	07.07.24	1:5	

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>9</i>	CHECKED <i>h</i>	MFG. APPR. <i>E</i>	APPROVED <i>W</i>	DE APPR. <i>#</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR.09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
W

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W/0 53897